



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 182629



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/29/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		9/21/18	0.00	0.00	Start Up Skidtubes		
110	CNC Bend Skidtubes	1 pcs		9/21/18	0.00	0.65	CNC Bend Skidtube		
120	Skidtubes	1 pcs		9/21/18	0.00	2.89	Skidtubes-2		
130	QC	1 pcs		9/21/18	0.00	0.00	QC5		
140	Skidtubes	1 pcs		9/21/18	0.00	2.89	Skidtubes-2		
150	QC	1 pcs		9/21/18	0.00	0.00	QC10		
160	QC	1 pcs		9/21/18	0.00	0.00	QC5		
170	HandFinish	1 pcs		9/21/18	0.00	1.31	HandFinish1		
180	Powdercoat	1 pcs		9/21/18	0.00	0.34	Powdercoat1		
190	QC	1 pcs		9/21/18	0.00	0.00	QC3		
200	HandFinish	1 pcs		9/21/18	0.00	1.31	HandFinish4		
210	QC	1 pcs		9/21/18	0.00	0.00	QC5		
220	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging3-1		
225	DC	1 pcs		9/21/18	0.00	0.00	DC		
230	QC21-FG	1 Ea		9/21/18	0.00	0.00	QC21		

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution

180 - START TIME: 11:25 OVEN TEMPERATURE: 600 FINISH TIME: 11:25
200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 M138953 Sikaflex expire date: 14107 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 M138953 Sikaflex expire date: 14107 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5098120

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER : _____																																																																							

220 - Identify and pack for shipping as per PPPD205-634-041 Location:

PPP Rev:

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skidtubes
D4202-1	Spacer	20 Ea (20 ea)	140-Skidtubes
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish
D2594-3	O-Ring MS28775-011	16 Ea (16 ea)	200-HandFinish
D2855	Cap	1 Ea (1 ea)	200-HandFinish
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish

005698
 Container
 S108455
 5089827
 5099431
 5084123
 5095480
 5095223
 X F42803
 5084102
 5066018
 5080626
 500115
 5089612
 5107312
 507663
 5100403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	0	0
140-Skidtubes	D2576-3	1	54	0
	D4202-1	20	391	0
200-HandFinish	ALS7-1032-130	50	1,448	0
	AN3-5A	2	399	0
	AN3C4A	50	2,578	0
	D2594-1	16	109	0
	D2594-3	16	212	0
	D2855	1	56	0
	D3564-11	1	20	0
	D3564-13	1	16	0
	D3564-5	1	9	0
	D3564-9	1	8	0
	NAS1149C0332R	50	6,180	0
	NAS1149D0332J	2	2,695	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5081-1	FWD WEARPLATE
36				1	D5081-3	AFT WEARPLATE
50	50	50			ALST-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN980C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN980JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALST-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

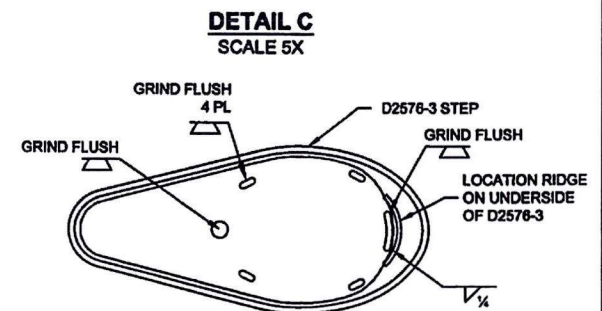
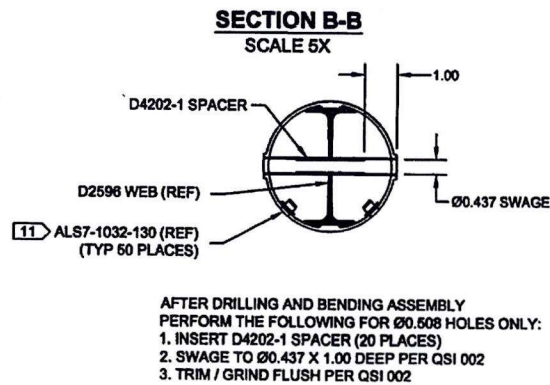
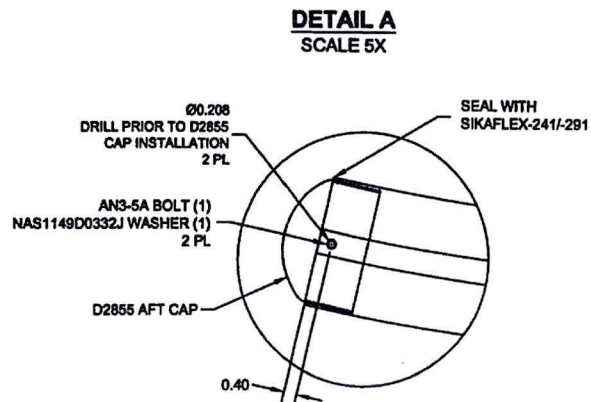
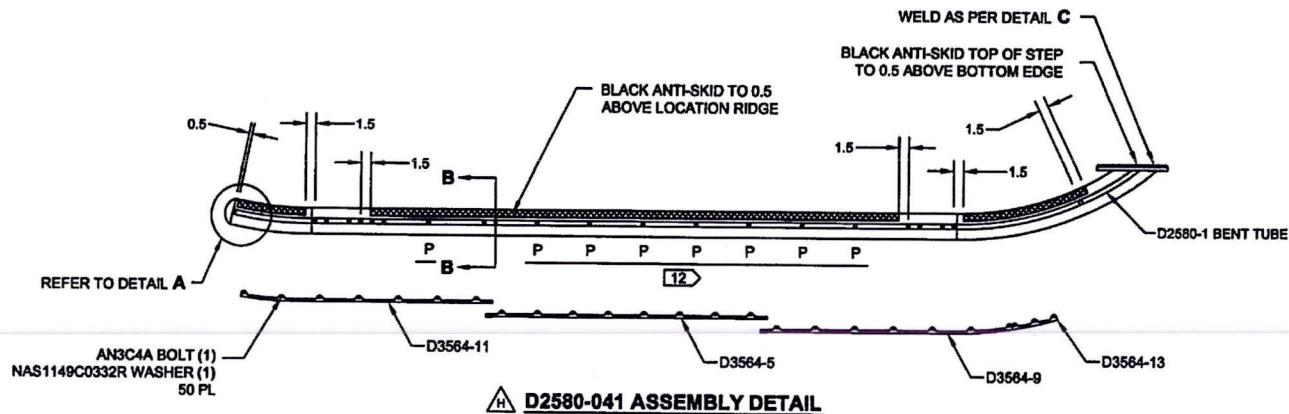
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 182629 MWS
18-08-29

RELEASED

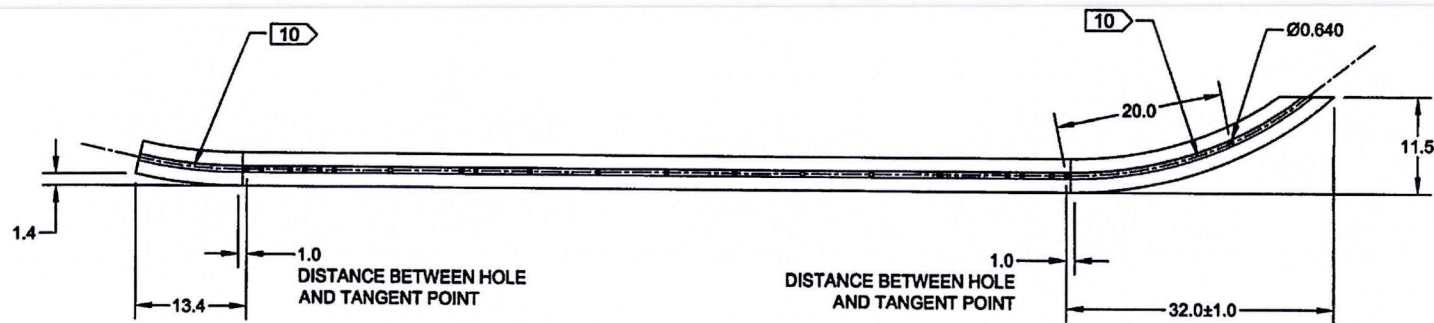
2017 JUL 05
ECN17-519

H	SHEET: PL DELETE D3586-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9506	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/ 8183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	John		
MFG. APPR.	13		
APPROVED	14		
DE APPR.	14		
DATE	17.06.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY REV. H SHEET 1 OF 9 SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXCLUSIVE ORDER THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



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2017 JUL 05

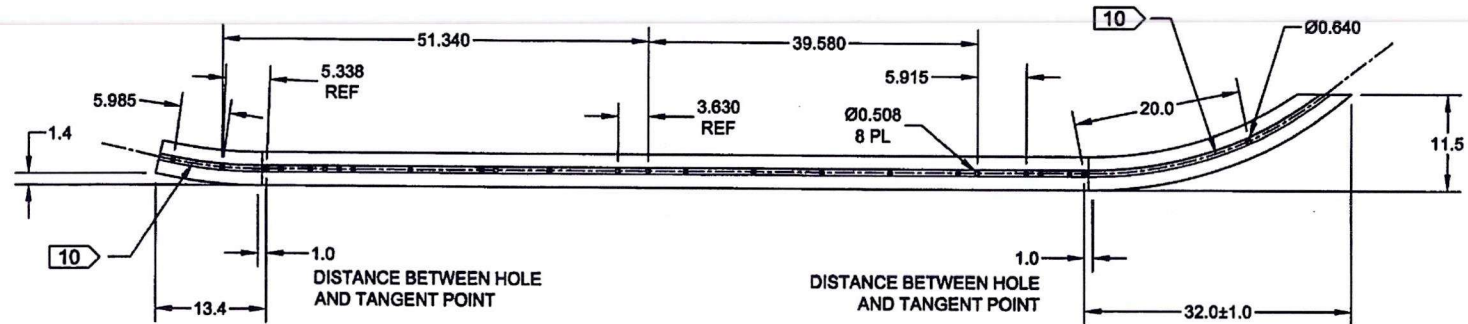
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 2 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	17.06.09		



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05 4P

DESIGN	DS	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

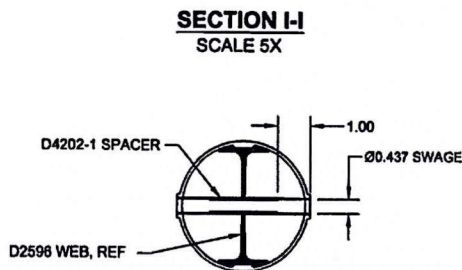
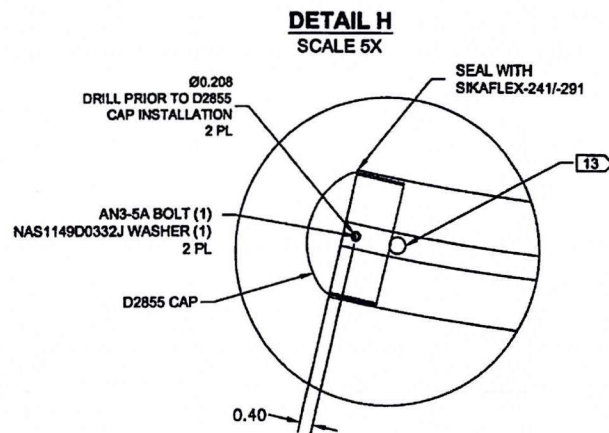
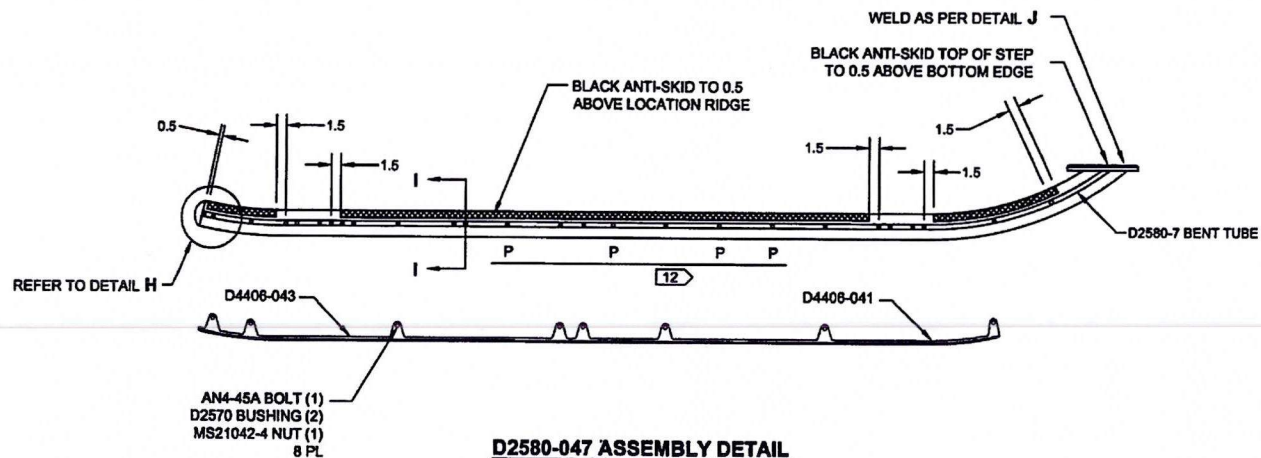


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

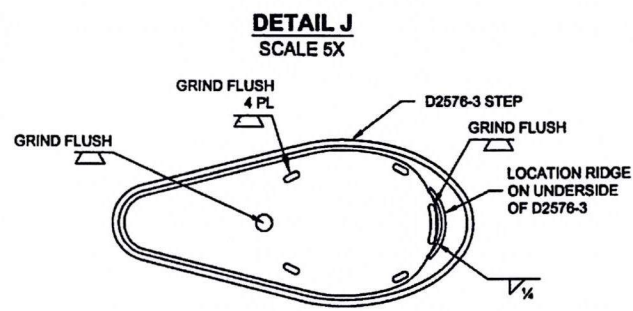
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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 5 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	17.06.09		



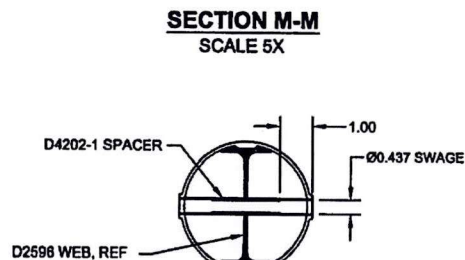
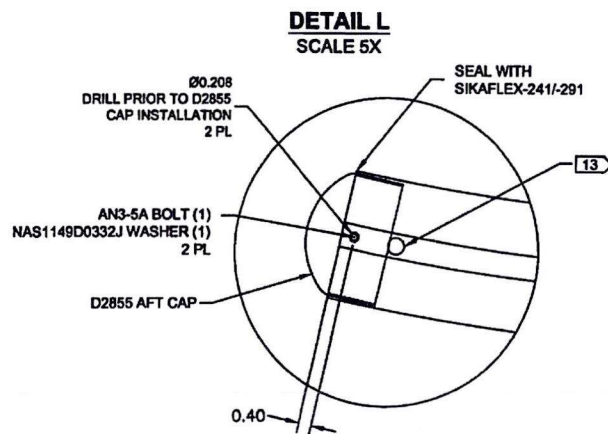
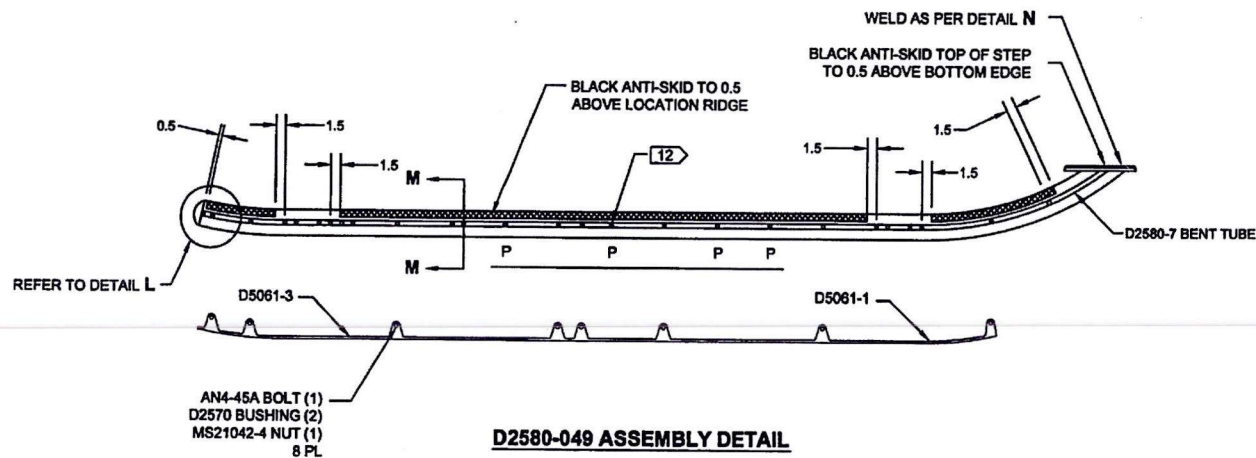
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



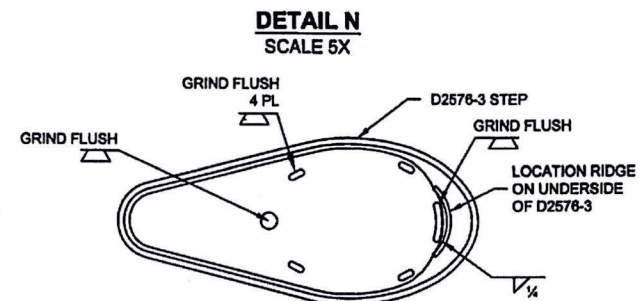
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DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H
MFG. APPR.	<i>[Signature]</i>		SHEET 8 OF 9
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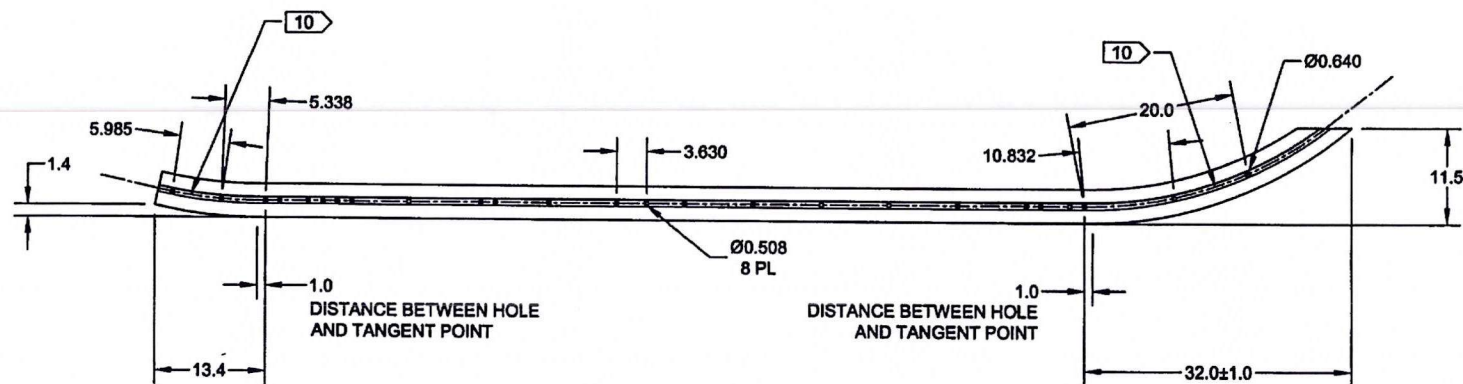
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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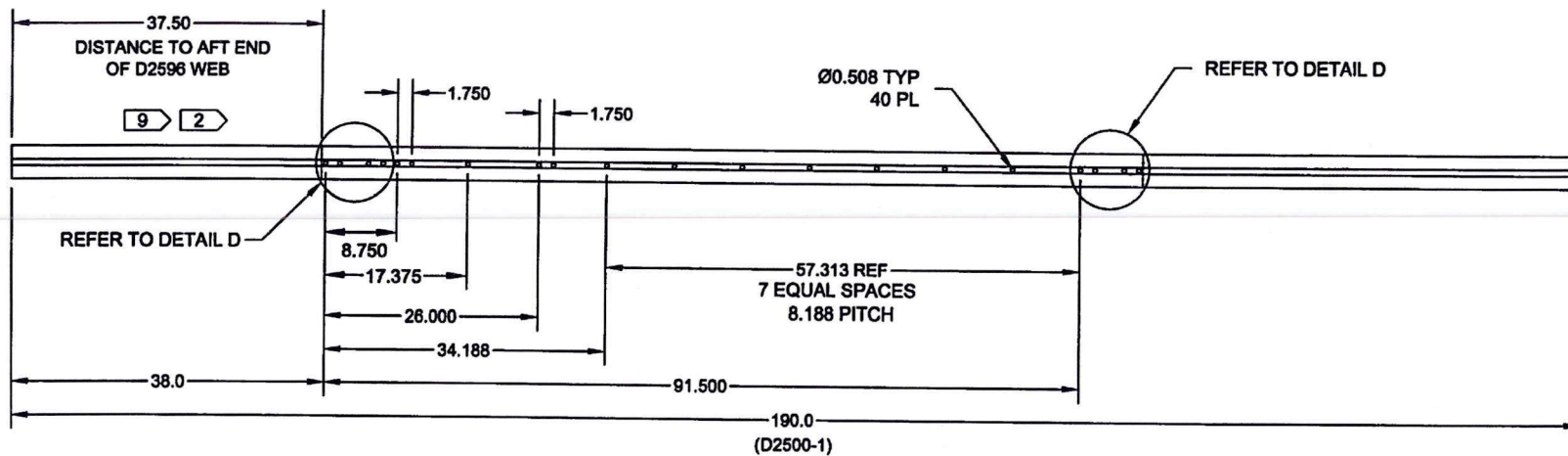
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DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H
MFG. APPR.	<i>[Signature]</i>		SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
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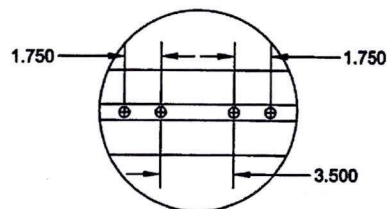
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>MB</i>	D2580	SHEET 8 OF 9
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

Change Record

PAGE 1 OF 1

Part Number: D205-634-041/-041DG/-041GY

Description: REPLACEMENT SKIDTUBE w/ STANDARD WEARPLATES, LH/RH

[illegible]